

RUSH 1

# Work Order ID 66872



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Tuesday, March 01, 2011 1:22:38 PM

Item ID:	D4150-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Attachment Arm Assembly					
Start Date:	3/1/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	3/2/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>C2</u>	Date:	<u>11/03/01</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4150	B								

100		0.00							
Small Fab	Memo	0.00	<u>SB</u>	<u>11/03/01</u>		<u>(1)</u>			
Small Fab	1- Assemble as per dwg								

110	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00	<u>S</u>	<u>11/03/01</u>		<u>(1)</u>			
Quality Control									

120	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
Packaging	Memo	0.00	<u>SB</u>	<u>11/03/02</u>		<u>(1)</u>			
Packaging	<u>w/o 6 6305</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66872**

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Item ID: D4150-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Attachment Arm Assembly

Start Date: 3/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/02

CL11/03/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 66872

Parent Item: D4150-041

Parent Item Name: Attachment Arm Assembly




Start Date: 3/1/2011

Required Date: 3/2/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC  
IPP Rev:B 10.07.22 as per revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C13A  Bolt		Purchased	No			100	Each	37.0000	2	2			
<div> <div>Location</div> <div>ST351</div> <div>115335</div> <div>115457</div> <div>115768</div> </div> <div> <div>Loc Qty</div> <div>37</div> <div>5</div> <div>12</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
D4150-1  Arm		Manufactured	No			100	Each	4.0000	1	1			
<div> <div>Location</div> <div>ST123</div> <div>61011</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D4150-3  Arm Plate		Manufactured	No			100	Each	2.0000	2	2			
<div> <div>Location</div> <div>ST123</div> <div>61012</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

SB 11/23/01

SB 11/03/01

SB 11/03/01

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 66872



Parent Item: D4150-041



Parent Item Name: Attachment Arm Assembly

Start Date: 3/1/2011

Required Date: 3/2/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-3 Purchased No

100 Each

1,179.000 2 2



SB 11/03/01

Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1103

112314

1103

2

NAS1149C0332R Purchased No

100 Each

2,658.000 4 4



SB 11/03/01

Washer

Location

Loc Qty

Loc Code

ST297

2658

115000

125

115698

35

116025

108

116304

2390

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

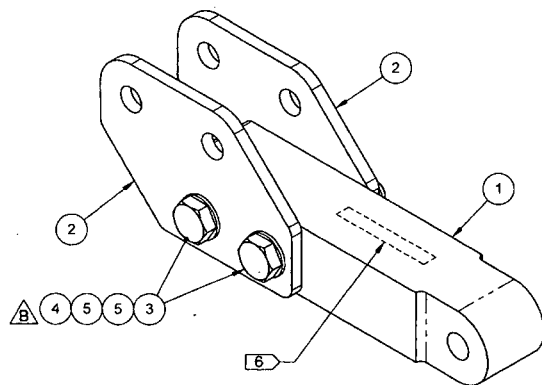
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D4150-041 ATTACHMENT ARM ASSY**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4150-041	ATTACHMENT ARM ASSY
1	1	D4150-1	ARM
2	2	D4150-3	ARM PLATE
3	1	AN3C13A	BOLT
4	1	MS21043-3	NUT
5	2	NAS1149C0332R	WASHER

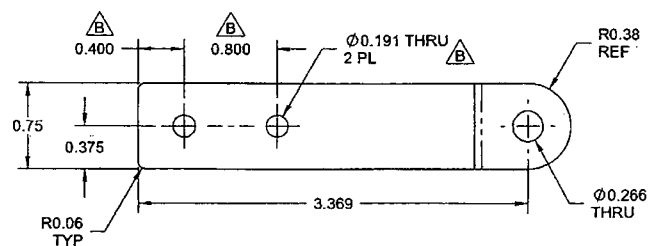
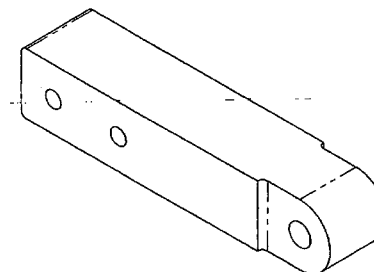
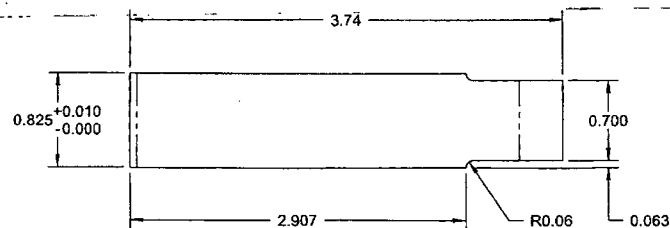
C211103/01  
W/O. 66872

**RELEASED**  
2010-07-16

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.82 lbs

B	REPLACED QTY(3) MS20615-4M20 WITH QTY(2) EACH AN3C13A MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C8-2, C7-2, B4-3 & B5-3). REASON: SEE TR-D350-607-2 REV. B.		MB	10.07.08
A	NEW ISSUE		MB	10.06.18
REV.	DESCRIPTION	BY	DATE	
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	DRAWING NO. REV. B			
CHECKED	D4150 SHEET 1 OF 3			
MFG. APPR.	TITLE SCALE			
APPROVED	ATTACHMENT ARM ASSY NTS			
DE APPR.	DATE: 10.07.08			
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**D4150-1 ARM**

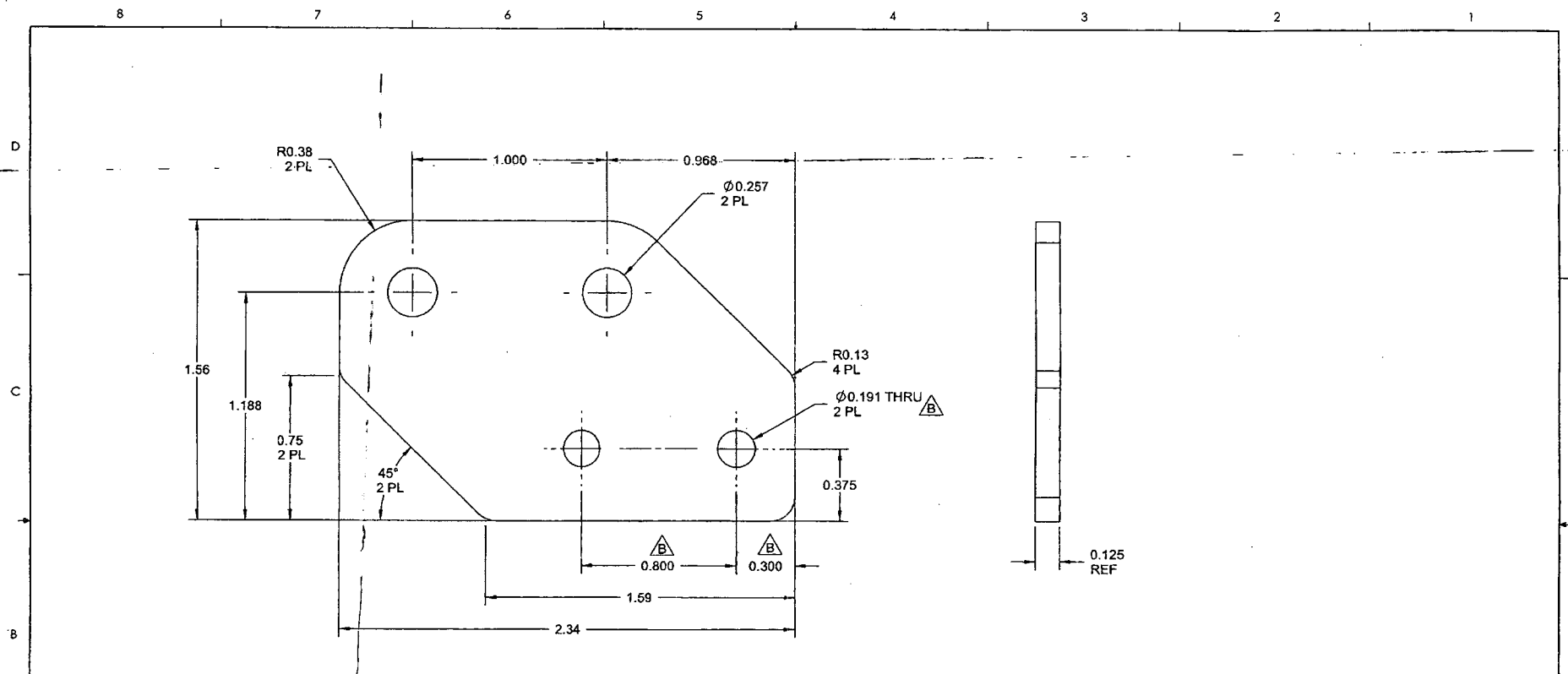
W10:66872

**RELEASED**  
 2010-07-16  
 MP

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276  
 REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
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**D4150-3 ARM PLATE**

w/o: 66872

**RELEASED**  
2010-07-16

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D4150	SHEET 3 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		ATTACHMENT ARM ASSY	NTS
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DATE	10.07.08		